

Work Order ID 89292

August-24-12 12:54:46 PM

89292

Page 1

Item ID: D3463-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm

Start Date: 8/21/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/07/12 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3463

Rev B

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 25.00 " long

0.00

0.00

12-09-04

4

105

105

Lathe Conv

Conventional Lathe

Memo

Ream tube at both ends aprox 2" deep at .750" Dia

0.00

0.00

12-09-04

4

110

110

Small Fab

Small Fab

Small Fab

Memo

1-Bend as per dwg D34632-Trim to lenght per dwg D34633- Deburr

0.00

0.00

4

FF 12-11-07

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Item ID: D3463-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm

Start Date: 8/21/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/07/12 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|-----------------------------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim. | 0.00 0.00 | | DAS 15 2-88 121107 | | 4 | | | |
| 130 *130* Mill Conv Conventional Milling Machine | CONVENTIONAL MILLING MACHINE Memo 1- Drill as per dwg D3463(One side only) 2-Deburr as per dwg D3463 | 0.00 0.00 | | 2-11-21 | | 4 | | | |
| 140 *140* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | | 2-11-21 | | 4 | | | |

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Item ID: D3463-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 8/21/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/07/12

Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: *w/h*

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/11/23

MF 12-11-22

Picklist Print

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Page 1

Work Order ID: 89292

Parent Item: D3463-1

Parent Item Name: Arm

Start Date: 8/21/12

Required Date: 9/07/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC
LATHE STEP 10-06-02 JLM VER:DD

IPP REV:B ADDED MANUAL

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M316TR1.00W.120 316 RD tubing 1.00 x .120w | | Purchased | No | | | 100 | f | 86.5000 | 2.083 | 8.7705264 | | | |

Location

Loc Qty

Loc Code

MAT037

86.5

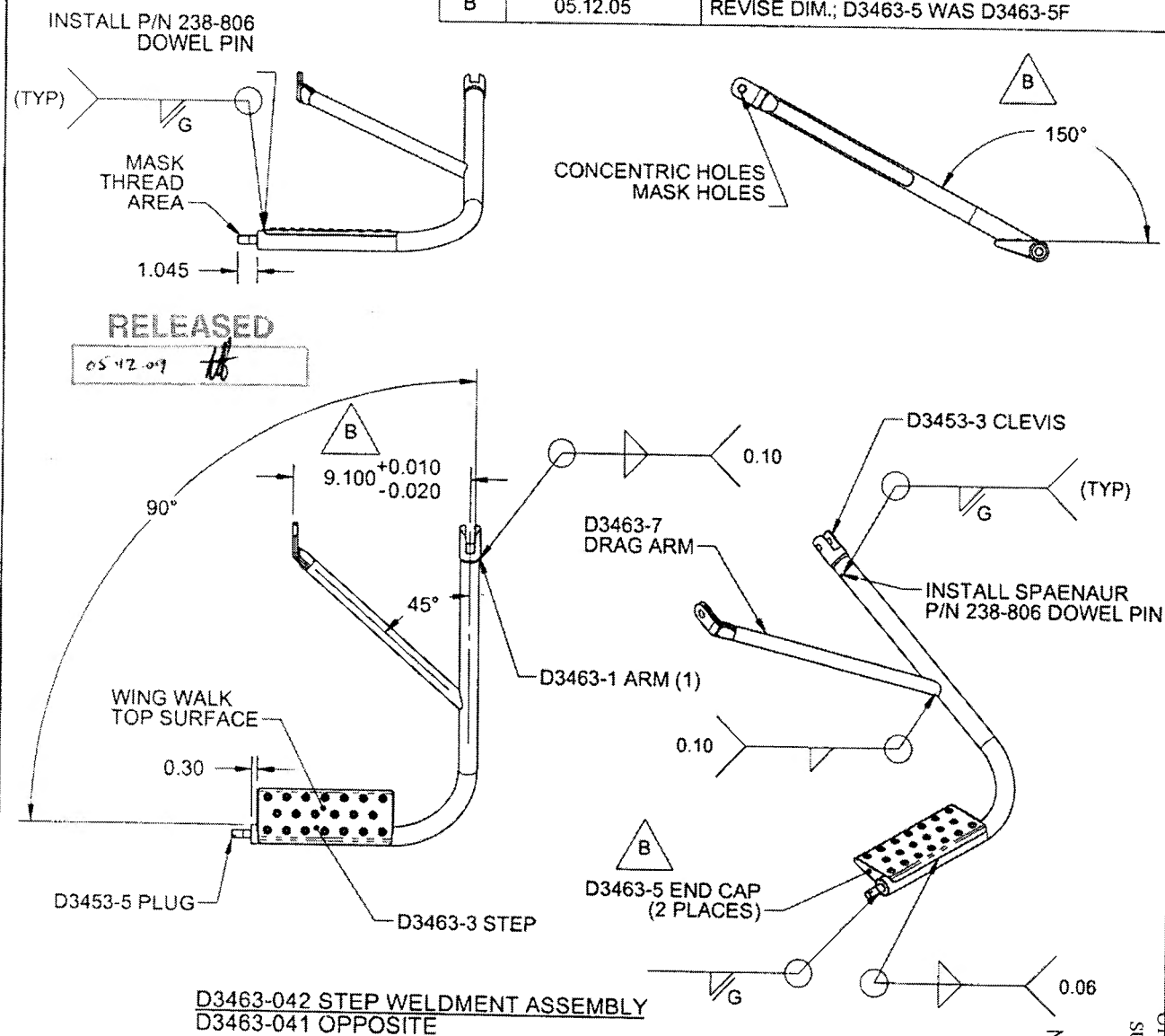
121247

86.5

9.1 12-09-04



| | | | |
|------------------|------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 1 OF 4 |
| DATE 05.12.05 | TITLE STEP WELDMENT | | |
| A | 05.09.20 | NEW ISSUE | |
| B | 05.12.05 | REVISE DIM.; D3463-5 WAS D3463-5F | |



D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE

NOTES:



- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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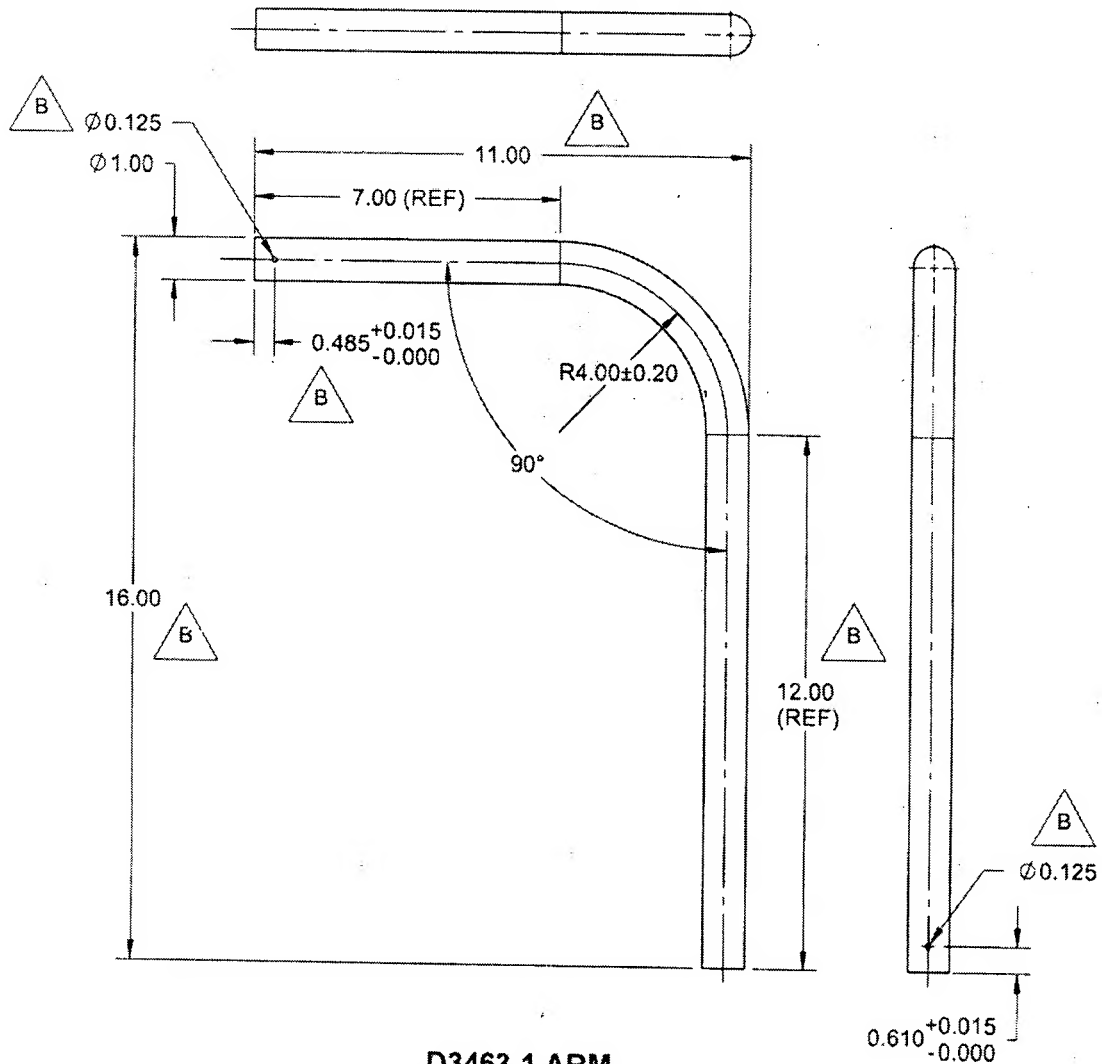

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WORK ORDER
NO. 89252M25
12/08/21

DART

| | | | |
|--|---|---|--------------|
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| CHECKED  | APPROVED  | DRAWING NO. D3463 | REV. B |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SHEET 2 OF 4 |
| | | | SCALE 1:4 |

RELEASED

05.12.09 **D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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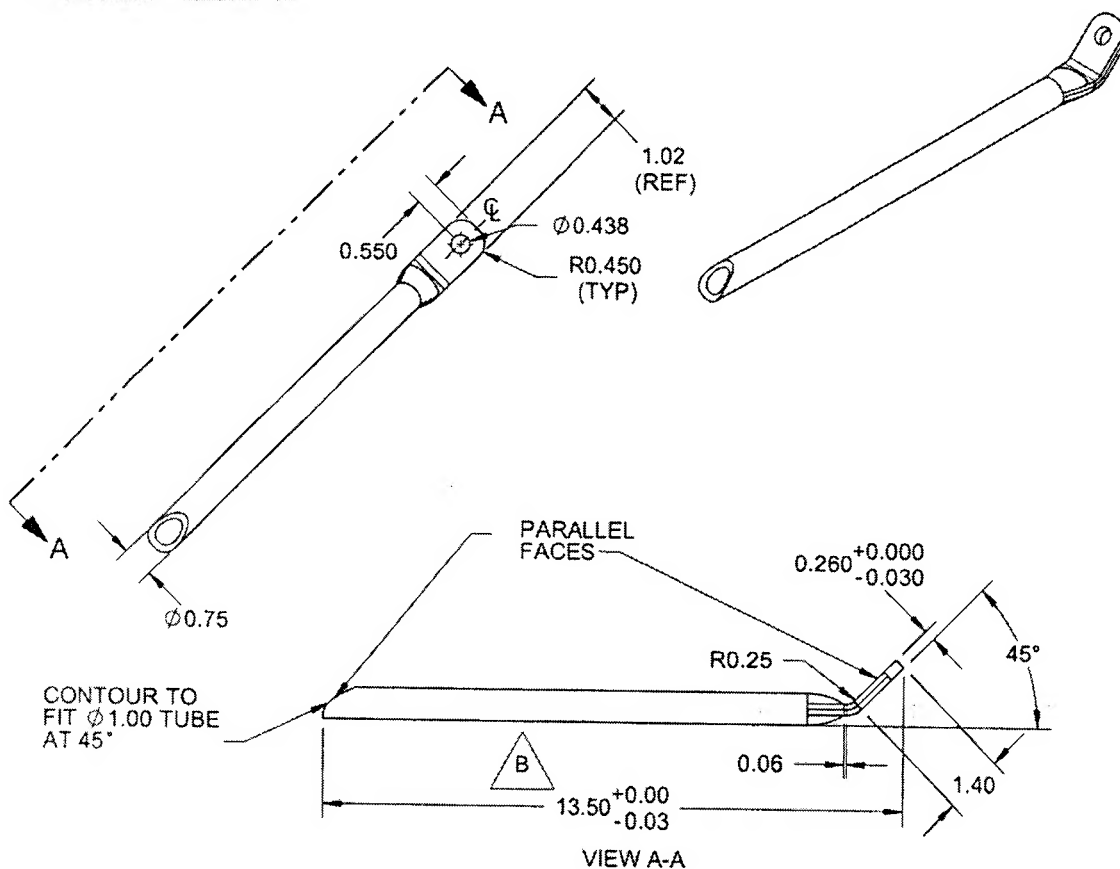
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| | | | |
|------------------|----------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 3 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:4 |

RELEASED

05.12.05 #



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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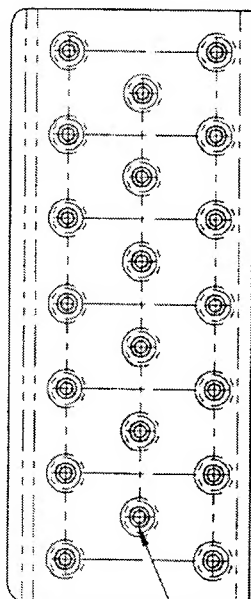
89292



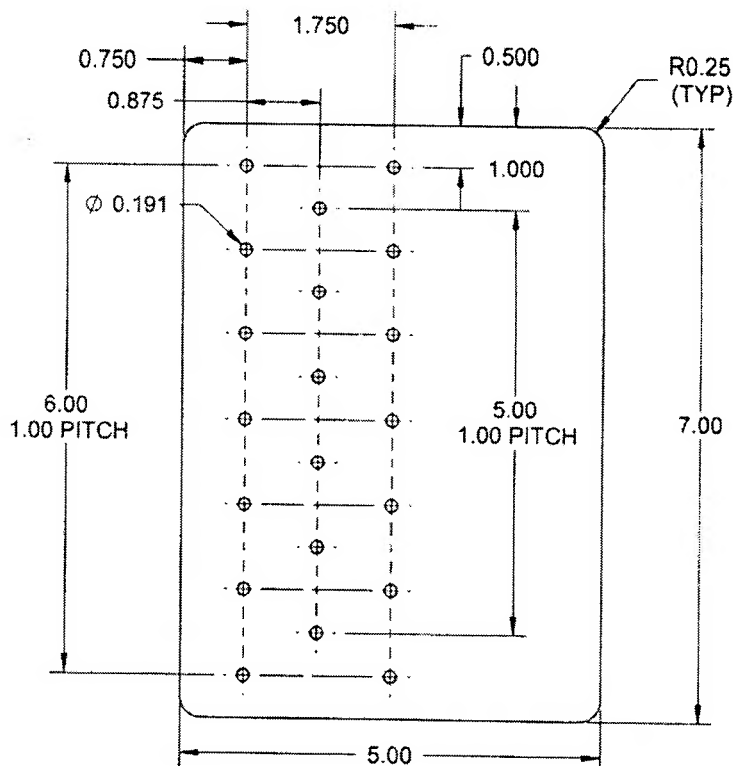
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| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 4 OF 4 |
| DATE 05.12.05 | TITLE STEP WELDMENT | | |
| | | | SCALE 1:2 |

RELEASED

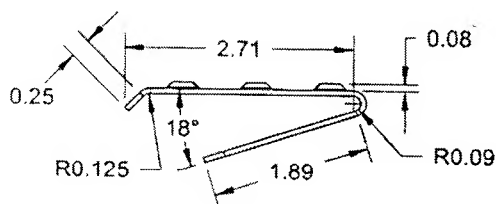
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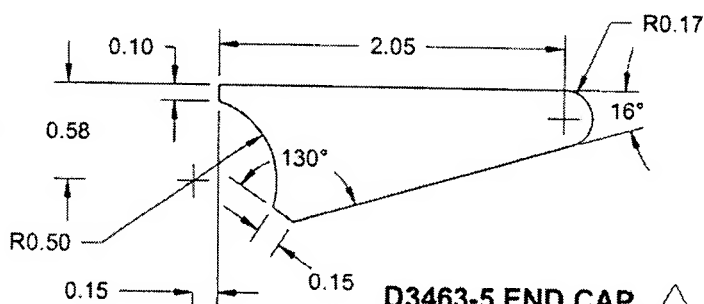
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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04292

FIRST ARTICLE INSPECTION CHECKLIST

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

10.04.15